

Date: Wednesday, 3/12/2008 1:50:51 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BACK FRAME ASSEMBLY
Job Number : 37871	
Estimate Number : 11129	
P.O. Number :	Part Number : D3017041
This Issue : 3/12/2008 S.O. No. :	Drawing Number : D3017 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 37870	Material :
Written By : <u>                    </u>	Due Date : 4/11/2008 Qty: 1 Um: Each
Checked & Approved By : <u>                    </u>	
Comment : Est. A 01.09.19 New issue EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M4130NT0750W049	4130 Tube .750 OD x.049W
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Comment: Qty.: 13.1250 f(s)/Unit Total : 13.1250 f(s)  
 4130 Tube .750 OD x.049W  
 Cut:- AISI 4130N tube, Ø3/4" x 0.049" wall  
 Batch: M103012

PD 08-06-05

2.0	M4130NS049	4130 Sheet .049 wall
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Comment: Qty.: 0.1260 sf(s)/Unit Total : 0.1260 sf(s)  
 4130 Sheet .049 wall  
 Cut:- AISI 4130N sheet, 18 gauge (0.050 thick)  
 Batch: M11612

PD 08-06-10

3.0	D30177	Lug
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)  
 Lug  
 Pick:  
 Qty Part Number Description Batch  
 3 D3017-7 Lug B30867

PD 08-06-05

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1  
 1-Cut all tubes as per Dwg D3017  
 2-Cut end caps as per Dwg D3017  
 3-Weld as per Dwg D3017 using Welding Jig Dt8598  
 A/R Steel Rod Batch: M100015

PD 08-06-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/12/2008 1:50:51 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BACK FRAME ASSEMBLY

Job Number: 37871

Part Number: D3017041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Drill D3017-041 Using DT8621

5-Deburr

\*

1D 08-06-10

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/06/10

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/06/10

7.0

POWDER COATING

POWDER COATING



M 105642



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-1 08/

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/06/10

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: CA

SR 08/06/10

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/12

Job Completion



MF 08-06-12

30 min  
10/06/2008  
S.004 13.25  
#1 318.9 F  
#2 1337.71 F  
#3  
#4 D3017041

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



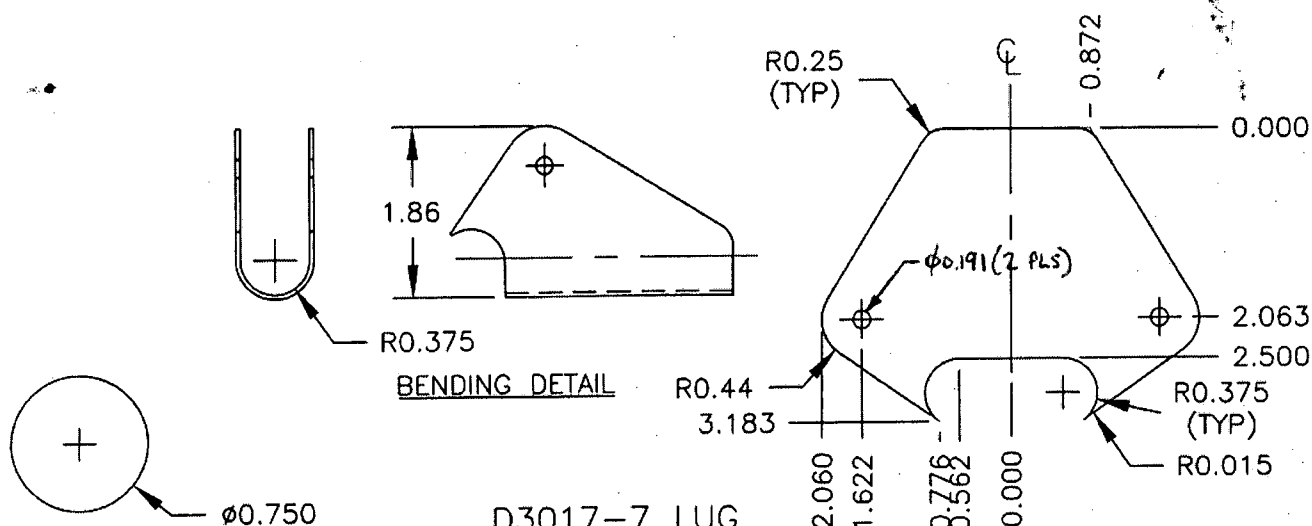
DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3017	REV. A SHEET 1 OF 2
DATE 01.05.18		TITLE BACK FRAME ASSEMBLY	SCALE 1:1
A	01.05.18	NEW ISSUE	

QTY	PART No.	DESCRIPTION	MATERIAL
X	D3017-041	BACK FRAME ASSEMBLY	N/A
1	D3017-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3017-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3017-5	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
3	D3017-7	LUG	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3017-11	END CAP	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)

#### NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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WORK ORDER  
NO. **37871**



D3017-11 END CAP  
SCALE 1:1

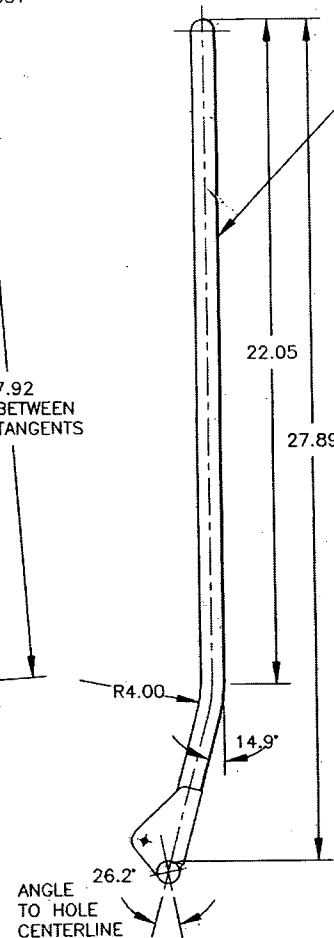
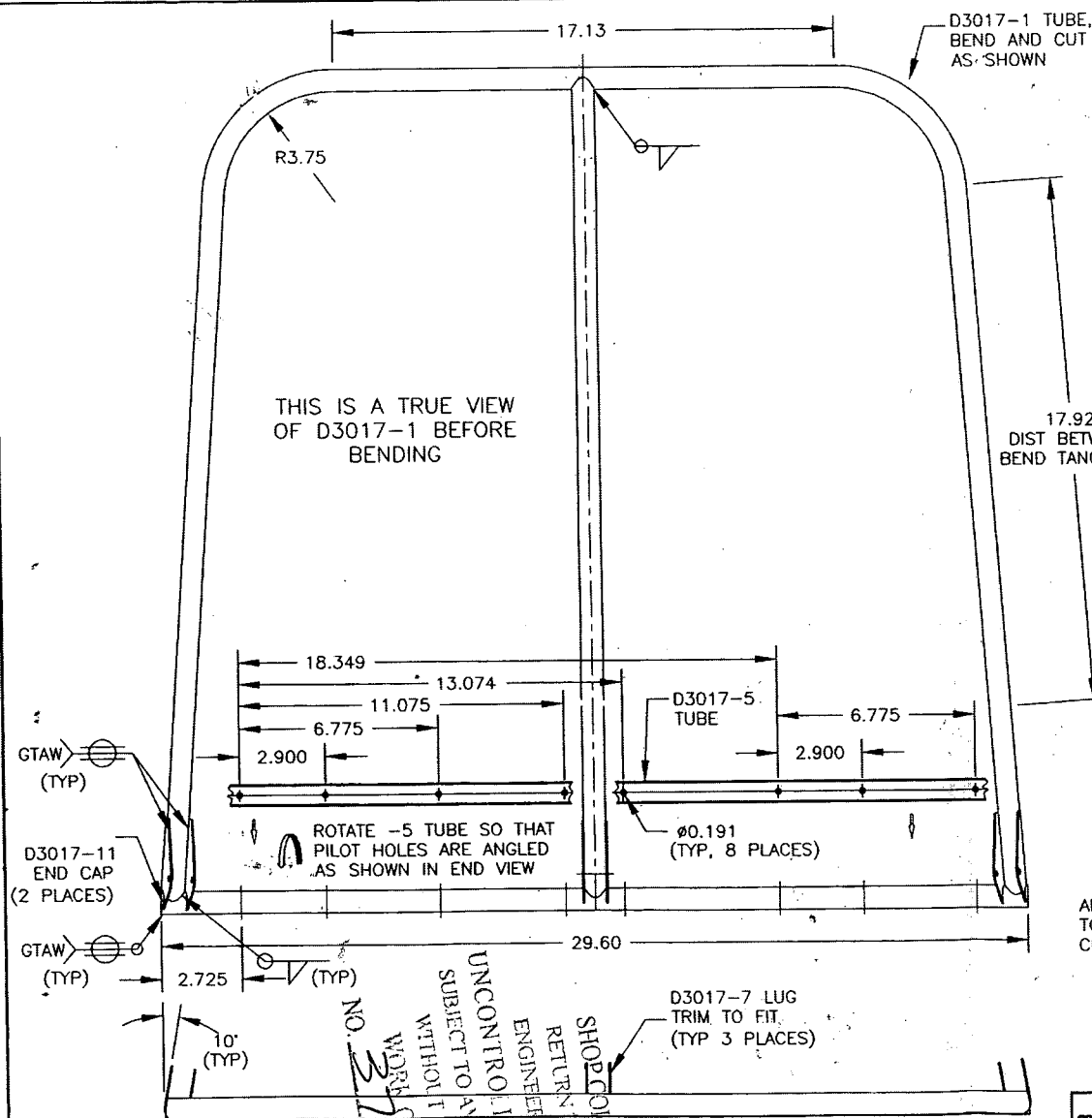
D3017-7 LUG  
SCALE 2:1

RELEASED  
01.05.30

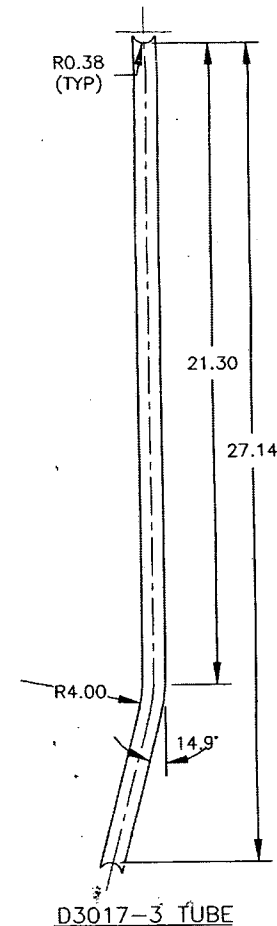
FLAT PATTERN  
PART IS SYMMETRIC  
ABOUT CENTERLINE

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DRILL Ø0.128 HOLES TO LINE UP WITH D3023-1 BACK PANEL



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01-06-07

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WORK CENTER  
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D3017-041 BACK FRAME ASSEMBLY  
(D3017-1 TUBE, D3017-5 TUBE)

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DESIGN	CP	DRAWN BY	CP	<b>DART</b>	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO.	REV. A
DATE	01.05.18	TITLE	BACK FRAME ASSEMBLY	D3017	SHEET 2 OF 2
					SCALE